

Work Order ID 85454

85454

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June-08-12 10:01:12 AM

Item ID: D2594-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Plug, 205 Skidtube

Start Date: 08/06/2012 Start Qty: 400.00

400

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 400.00

400

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/08

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2594	Rev C								
100		0.00							
100	Hardinge CNC LATHE SMALL								
Hardinge	Memo	0.00							
Hardinge CNC Lathe Small	1-Make as per Dwg D2594-1 and Folio FA262.2-Break all sharp edges 0.010 max.								
110		0.00							
110	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									
120		0.00							
120	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

29 12-6-22 429 ✓

29 12-6-22 429 ✓

SL 12-06-25

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Item ID: D2594-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Plug, 205 Skidtube

Start Date: 08/06/2012 Start Qty: 400.00

400

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 400.00

400

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

429 x 16 12-6-27

140

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

140

Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

8:50
3200F

9:20

424 x 16 M.A. 12/07/05

150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

429 x 16 12-7-5

W121841

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Item ID: D2594-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Plug, 205 Skidtube

Start Date: 08/06/2012 Start Qty: 400.00

400

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 400.00

400

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location: FP-2

0.00

160

Packaging

Memo

0.00

Packaging

429 0 0412-75

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

CK 12/7/10
ME
12-07-05

Picklist Print

June-08-12 10:01:16 AM

Page 1.

Work Order ID: 85454

85454

Parent Item: D2594-1

D2594-1

Parent Item Name: Plug, 205 Skidtube

Start Date: 08/06/2012

Required Date: 22/06/2012

Start Qty: 400.00

Required Qty: 400.00

Comments: IPP D02.08.22Make in CobraKJ
IPP E 06.12.11 ecn 836 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.625		Purchased		No		110	f	27.6430	0.0521	21.93684			

M6061T6R0 625

6061-T6 Round Bar .625"

**

22.6.22

Location	Loc Qty	Loc Code
MAT012	27.643	
117284	0.184	
119346	0.559	
120603 ✓	26.9	

122081

19.6

22.1

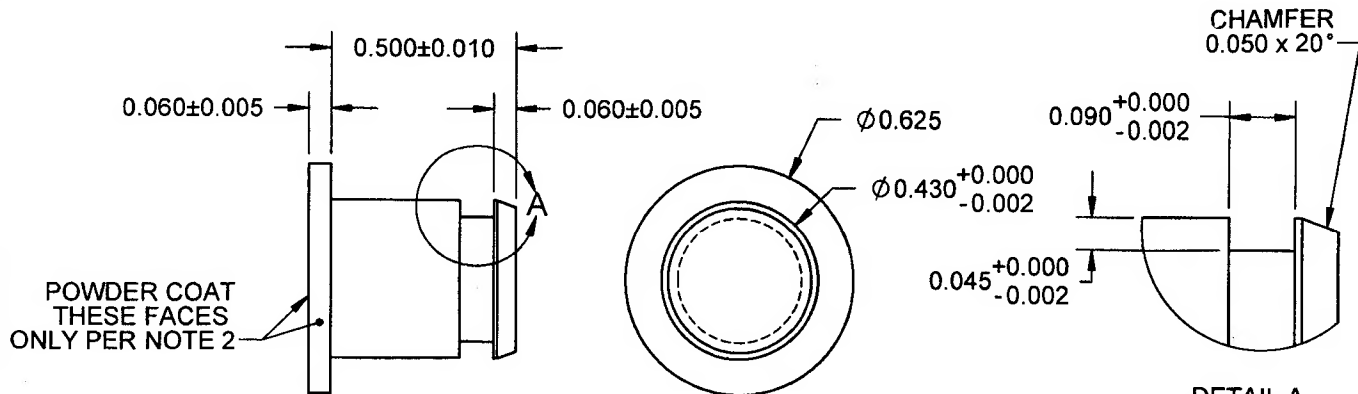




DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D2594	REV. C SHEET 1 OF 1
DATE 06.11.20	TITLE PLUG SCALE 2:1		
REV	DATE	DESCRIPTION	
A	96.09.16	NEW ISSUE	
B	97.03.15	ADD GROOVE AND O-RING	
C	06.11.20	ADD PWDR COAT; ADD MS P/N TO D2594-3; ADD AMS SPECS; ADD TOLERANCE NOTE	

RELEASED

06.11.28



D2594-1 PLUG

D2594-1 PLUG NOTES:

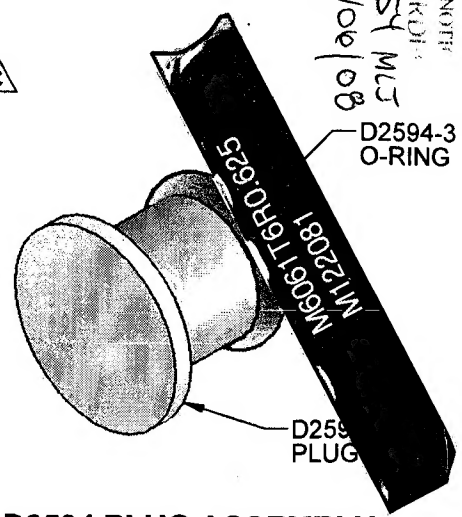
- 1) MATERIAL: ALUMINUM 5052-H32 ROUND BAR PER QQ-A-225/7 (REF DART SPEC M5052H32R) OR ALUMINUM 6061-T6/T651/T6510/T6511/T62 ROUND BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT SPECIFIED FACES WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

D2594-3 O-RING NOTES:

- 1) 5/16 ID, 7/16 OD, 1/16 WIDTH
- 2) POSSIBLE SUPPLIER P/N: PARKER 2-011 OR MS28775-011

PARTS LIST:

QTY	P/N	DESCRIPTION
X	D2594	PLUG ASSEMBLY
1	D2594-1	PLUG
1	D2594-3	O-RING



D2594 PLUG ASSEMBLY

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SHOP C
RETURN TO

ENGINEERING

UNCONTROLLED

SUBJECT TO AMEND

WITHOUT NOT

WORK ORD

NO. 8454

12/06/08